

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029109**Date Inspected:** 31-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** S.A.S. Job site**CWI Name:** Jesus Cayabyab**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Structure**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

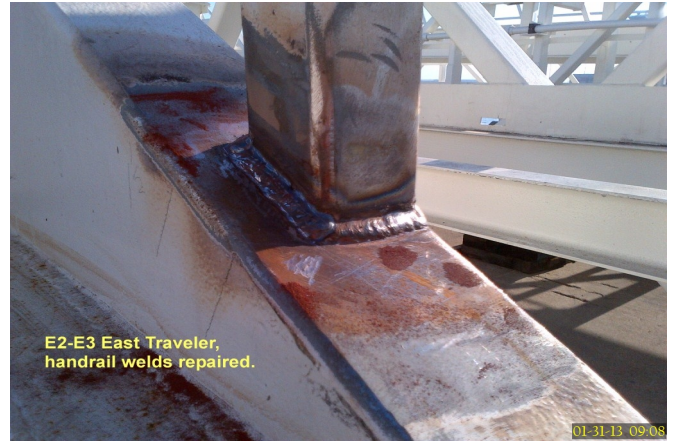
The QAI was informed that repair welding will be performed on the E2-E3 East Bound Traveler Platform. The QAI had previously reported that several handrail welds were not visually conforming to the contract requirements.

The QAI noted that ABF welder Kevin Kananen, ID 6521, was tasked with the repair of the fillet welds. When the QAI arrived at the pier 7 work location, the QAI was met by the Quality Control Inspector (QCI) Jesus Cayabyab. The QCI informed the QAI that all weld repairs were completed and acceptable. The QAI was informed that shielded metal arc welding was used to make the repairs and that magnetic particle testing (MT) was also conducted on the completed welds. The QAI made visual examination of the welds and noted that they appeared to be conforming to the contract requirements. See the attached photos.

The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. The QAI continued reviewing the contractor's submitted Electro-Slag Welding (ESW) reports and referencing the Requests for Weld Repair (RWRs) in order to determine the status of completion of the repairs and welds' overall reported condition. The QAI continued reviewing welding report packages 142 & 143, for contract conformance. The QAI noted that during the document reviews, previously submitted welding inspection and testing reports are being identified as needing corrections / revisions. These reports are being copied / noted and will be provided to the contractor for additional information. This work was in progress at the end of the shift.

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Summary of Conversations:

The QAI relayed the status of the document / submittal reviews and handrail repairs to the QAI Lead Danny Reyes.

Except as described above, there were no other notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas, (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Reyes, Danny	QA Reviewer
